

Work Order ID 150332

Thursday, September 15, 2016 9:48:09 AM

150332

Page 1

Item ID: 646.9601 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 8/19/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 8/24/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 15 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
646.9600	N/C		DAS 6 9-89	SEP 20 2016					

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

120 0.00
120
Small Fab Memo 0.34
Small Fab Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.
A/R RTV LOCTITE 598: **135479**
exp. date: **04/18**

130 QC5- Inspect part completeness to step on W/O 0.00
130
QC Memo 0.01
Quality Control

DAS 36 9-89

DAS 38 9-89

SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thursday, September 15, 2016 9:48:09 AM

150332

Page 2

Item ID: 646.9601

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Assembly

Start Date: 8/19/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: CCF039

0.00

140

Packaging

Memo

0.01

Packaging

IDENTIFY AS PER IAW MPP-120

SEP 28 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.05

Quality Control

DAS
21
9-89

SEP 30 2016

DAS
21
9-89

SEP 28 2016

SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																					

Picklist Print

Thursday, September 15, 2016 9:48:13 AM

Page 1

Work Order ID: 150332

150332

Parent Item: 646.9601

646 9601

Parent Item Name: Upper Cutter Assembly

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	4.0000	1	3			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					cck012			4		3			
					145346			4					
646.9811 *646 9811* Upper Deflector		Manufactured	No			110	Each	6.0000	1	3			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					cck011			6		3			
					128452			6					
MS21042L08 *MS21042L 08* Nut		Purchased	No			110	Each	817.0000	3	9			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					GA			118					
					m134063			18					
					m135274			100					
					ST303			699					
					m135408			125					
					m135466			174		9			
					m135536			200					
					m135566			200					

SEP 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Picklist Print

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Page 2

Work Order ID: 150332

150332

Parent Item: 646.9601

646 9601

Parent Item Name: Upper Cutter Assembly

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 3.00

Required Qty: 3.00

MS27039-08-19

Purchased

No

110

Each

470.0000

3

9

MS27039-08-19

Screw

DAS
6
8-29

Location

Loc Qty

Loc Code

GA

1

m135046

1

ST277

469

m135408

69

m135536

100

m135566

300

9

NAS1149FN832P

Purchased

No

110

Each

3,036.000

6

18

NAS1149FN832P

Washer

DAS
6
8-29

Location

Loc Qty

Loc Code

GA

1537

M133769

89

M135058

1448

ST263

1499

M135603

1499

18

SEP 20 2016

DQA: _____ Date: _____



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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600	REV IN/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: CUTTER ASSY					
	APPROVED BY: ENGR <i>P. Brans</i>	MFG <i>Armit Gargan</i>	QC <i>Maial Lezan</i>	EFFECT: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH.					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150332 MLS
160826

3	R	601.3157	3	3	3	SCREW	MS27039-0818	
			.9603	.9602	.9601			
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION	
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE
	LAST PROTOTYPE REVISION, PRI		ENC
ENC	INITIAL RELEASE	04/30/07	P. B. N. C.

**UNINCORPORATED ECN(s)**

	I		B	646.9812	LOWER DEFLECTOR LOW				
	I		7	646.9812	LOWER DEFLECTOR HIGH				
		I	5	646.9811	UPPER CUTTER DEFLECTOR				
A/R	A/R	A/R	5	601.2045	RTV, LOCITIE 598				
3	3	3	4	601.1541	LOCKNUT		MSS2/GA20B8		
3	3	3	3	601.2765	SCREW		MSS2703R-CHS19		
6	6	6	2	601.2764	WASHER		MS1154PFRH52P		
I	I	I	1	646.9701	CUTTER SUB ASSY				
X	X	X		646.9603	LOWER CUTTER ASSY LOW				
X	X	X		646.9602	LOWER CUTTER ASSY HIGH				
X	X	X		646.9601	UPPER CUTTER ASSY				
.9603	.9602	.9601	FIN#	PART #	DESCRIPTION		MATL	SPEC	
QTY				PARTS LIST					
NEXT ASSY (S)				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 CUTTER ASSY					
646.9500									
ORIGINAL DATE _____ INVOICE NO. _____ DRAFT BY _____ CHECKED BY _____ APPROVED BY _____ SPECIAL CONTRACT (Yes) _____				SEE PAGE CODE _____ DWG NO. 646.9600 SCALE NONE					REV N/A
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACES DECIMALS ± .01 ANGLES ± .5°				SHEET 1 OF 1					